

### Work Order ID 52498

September 28, 2009 9:46:01 AM

Item ID:

بخ

D2012-117

**Revision ID:** 

C Clevis

Item Name: Start Date:

9/28/09

Start Qty: 12.00

Required Date: 9/29/09

Req'd Qty: 12.00

Accept

Setup Start

Stop



Reference:

**Approvals:** 

**Process Plan:** 

QC:

Date:

Date:

SPC (Y/N):

Tooling:

Set Up/

**Run Hours** 

Date:

**Cust Item ID:** 

**Customer:** 

Draw

Number

Date:

Draw

Rev.

Plan

Code

Run

Accept

Qty

Start

Reject

Qty

Stop

Reject

Number

Insp.

Stamp

Sequence ID/ Work Center ID

Operation Description

**Revision Nbr** 

Rev C

Draw Nbr D2012-117

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo 1-Cut as per Dwg D2012

Dwg Rev: Prog Rev:

0.00

0.00

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

出午やみ

120

Quality Control

QC8- Inspect parts - second check

Memo

0.00

#### Work Order ID 52498

September 28, 2009 9:46:01 AM

Item ID:

D2012-117

C

**Revision ID:** Item Name:

**Start Date:** Required Date: 9/29/09

9/28/09

Clevis

Req'd Qty: 12.00

**Start Qty: 12.00** 

Reference:

Approvals:

Sequence ID/

**Work Center ID** 

**Process Plan:** 

QC:

Date:

Date:

SPC (Y/N):

Accept

Set Up/ **Run Hours** 

0.00

**Tooling:** 

0.00

NC BRAKE

**Operation** 

**Description** 

Brake NC

Brake NC

130

140

Memo

Form on press using DT8242 as per Dwg D2012-117

QC5- Inspect part completeness to step on W/O

Memo

Identify as per dwg & Stock Location: KAB

Memo

0.00

0.00

Setup Start

Stop



**Cust Item ID: Customer:** 

Draw

Number

Date:

Date:

Draw

Rev.

Plan

Code

Run Start

Stop

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

9/9/28 (3/2)Sq

150

Packaging

Quality Control

Packaging

# Work Order ID 52498

September 28, 2009 9:46:02 AM

Item ID:

D2012-117

 $\mathbf{C}$ 

**Revision ID:** 

Item Name: Clevis

**Start Date:** 9/28/09 Required Date: 9/29/09 Start Qty: 12.00

Req'd Qty: 12.00



Accept

Run

Setup Start

Stop



**Cust Item ID:** 

**Customer:** 

Draw

Number

Reference:

Approvals:

**Process Plan:** 

QC:

Date:

Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Start

Stop

Sequence ID/

**Work Center ID** 

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ Run Hours

0.00

Accept Reject Draw Plan Qty Rev. Code Qty

Reject Number

Insp. Stamp

160

QC

Quality Control

Memo

0.00

09/09/29 TX MF 29-09-29

## **Picklist Print**

September 28, 2009 9:46:00 AM

Work Order ID: 52498

Parent Item:

D2012-117RevC

Parent Item Name: Clevis

**Comments:** 

Component Item ID/	Replacement	Mfg/
Item Name	Item ID	Purch

M304S16GA

304/316 Sheet .063

Last

Location

Route

Seq ID

100

Primary

Item Location

Bin

No

Purch

Purchased

**Start Date: 9/28/09** 

**Start Qty: 12.00** 

Qty on Remaining Qty Hand Qty To Pick Issued

Occor.

Required Date: 9/29/09

Required Qty: 12.00

Issued

Date

Status

162.6376 0.1731 

184-9-78

Warehouse	Loc Qty	Loc Code	
<b>Location</b>			
Main Warehouse			
MAT	162.6375737		
106860	16.018		
111924	25.1689737		
112442	61.0716		
112567	60.379		112567

Unit of

sf

Measure Hand

DART AEROSPACE LTD	Work Order:	52498
Description: CLEVIS	Part Number:	D 2012 - 117
Inspection Dwg:D>613-117 Rev:		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
\$ .197	100200.4	1901	*	*		
T26. 3	+.006001	.363	*			
,380	4010		×			
.750	4- 010		*			
-390	4010	_390	×			
1.325	4-010	1,325	8			
2.649	7010	2.650	*			
.063	4010	,060	>			·
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				ļ		

Measured by:	B	Audited by:	8, ,	Prototype Approval:	N/A
Date:	9-9-38	Date:	e7 05 26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	
- /1		(1011)0000		

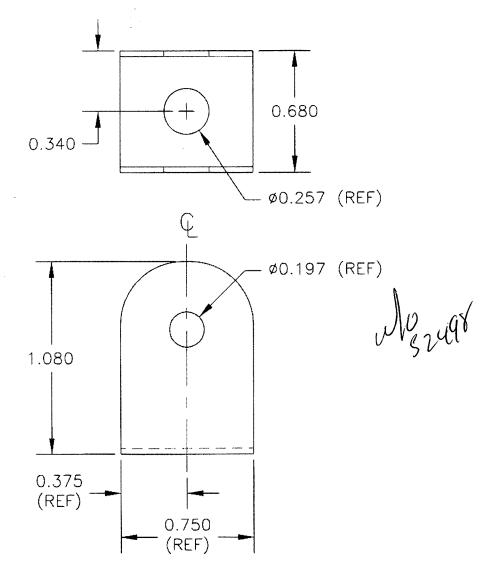




DES	BW	DRAWN BY		AEROSPACE LTD BURY, ONTARIO, CANADA	
CHI	ECKED KE	APPROVED -	DRAWING NO. D2012-117	SHEET	REV. C 1 OF 2
DAT	Ε		TITLE		SCALE
99	0.05.05		CLEVIS		2:1
ĪΑ		94.10.27	NEW ISSUE		



Α	94.10.27	NEW ISSUE
В	94.10.27	CHANGED HOLE SIZE, WAS D2012-107
С	99.05.05	ADD FLAT PATTERN



MATERIAL: AISI 304/316 SS 0.063 THICK

USE 0.032 BEND RADIUS

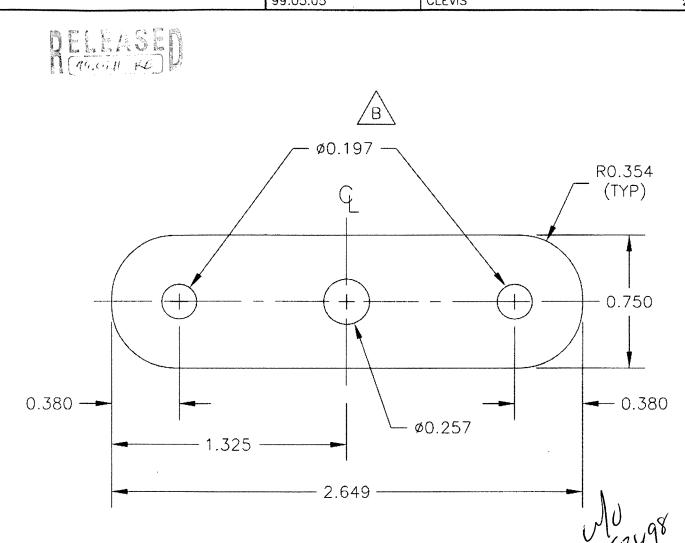
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES





DESIGN BW	DRAWN BY		OSPACE LTD ontario, canada
CHECKED	APPROVED	DRAWING NO.	REV. C
RE	-H	D2012-117	SHEET 2 OF 2
DATE		TITLE.	SCALE
99.05.05		CLEVIS	2:1



MATERIAL: AISI 304/316 SS 0.063 THICK TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES

D2012-117 FLAT PATTERN